

TITLE**POLY(TRIMETHYLENE DICARBOXYLATE)
FIBERS, THEIR MANUFACTURE AND USE**

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RELATED APPLICATIONS

This application claims priority from U.S. Provisional Patent Application Serial No. 60/434,751, filed December 19, 2002, which is hereby incorporated by reference.

FIELD OF THE INVENTION

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This invention relates to a process for spinning poly(trimethylene dicarboxylate) fibers, the resultant fibers, and their use.

BACKGROUND OF THE INVENTION

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Poly(trimethylene terephthalate) (also referred to as "3GT" or "PTT") has recently received much attention as a polymer for use in textiles, flooring, packaging and other end uses. Textile and flooring fibers have excellent physical and chemical properties.

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Textured polyester yarns, prepared from partially oriented polyester yarns or spun drawn yarns, are used in many textile applications, such as knit and woven fabrics (e.g., as the yarn for the entire fabric, the warp, weft or fill, or as one of two or more yarns in a blend, for instance, with cotton, wool, rayon, acetate, other polyesters, spandex and/or combinations thereof, etc.) for apparel and upholstery (e.g., furniture and automotive). Poly(ethylene terephthalate) textured yarns are commonly used for this purpose. Howell et al., in U.S. Patent 6,287,688 (which is incorporated herein by reference), have described preparing textured poly(trimethylene terephthalate) yarns and their benefits. The resultant yarns have increased stretch, luxurious bulk and improved hand, as compared to poly(ethylene terephthalate) yarns. Howell et al. describe preparing stable partially oriented poly(trimethylene terephthalate) yarns in a process with a spinning speed of up to 2600 meters per minute ("m/m"), and it has been desired to spin at higher rates.

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Preparing stable partially oriented poly(trimethylene terephthalate) yarns at high speeds using poly(ethylene terephthalate) conditions has not worked well. After spinning, a partially oriented yarn is typically wound onto a tube, or package, and the yarn packages are then stored or sold for use as a feed yarn in later processing operations such as drawing or draw-texturing. A partially oriented yarn package is not useable in subsequent drawing or draw-texturing

processes if the yarn or the package itself are damaged due to aging of the yarns or other damage caused during warehousing or transportation of the yarn package.

Stable partially oriented poly(ethylene terephthalate) yarns are typically spun at speeds of about 3,500 yards per minute ("ypm") (3,200 m/m). Since they typically do not age very rapidly, they remain suitable for downstream drawing or draw-texturing operations. In the past, attempts to make stable partially oriented poly(trimethylene terephthalate) yarns using a spinning speed in this same range have failed. The resulting partially oriented poly(trimethylene terephthalate) yarns have been found to contract up to about 25% as they crystallize with aging over time. In extreme case, the contraction is so great that the tube is physically damaged by the contraction forces of the yarn. In more common cases, the contraction renders the partially oriented poly(trimethylene terephthalate) yarns unfit for use in drawing or draw-texturing operations. In such cases, the package becomes so tightly wound that the yarn easily breaks as it is unwound from the package.

Spinning partially oriented poly(trimethylene terephthalate) yarns at slower speeds using equipment originally designed for partially oriented poly(ethylene terephthalate) yarns is inefficient. It is also problematic since the spinning and winding equipment is designed to run at higher speeds than those presently used for making poly(trimethylene terephthalate) yarns.

Spun drawn yarns are also used to make textured yarns, and there is also a desire to prepare spun drawn yarns at higher speeds.

It is also very desirable that the practitioner be able to make textured poly(trimethylene terephthalate) yarns from partially oriented and spun drawn poly(trimethylene terephthalate) yarns prepared at high speeds using the same or similar conditions to those produced at lower speeds. Thus, these yarns should have the same or similar elongations and tenacities.

Poly(trimethylene terephthalate) filaments and yarns have also been prepared for other purposes. For instance, bulked continuous filament ("BCF") yarns, their manufacture, and their use in flooring, are described in U.S. Patent Nos. 5,645,782, 5,662,980, and 6,242,091, which are hereby incorporated by reference. Fine denier yarns are described in U.S. Patent Publication No. 2001/0030377 A1 and U.S. Patent 6,383,632, which are incorporated herein by reference, and direct use yarns are described in U.S. Patent Publication No. 2001/0033929 A1, which is incorporated herein by reference. Staple fibers can be made from multifilament yarns as described in U.S. Patent Publication No. 2002/0071951 A1 and WO 02/22927, which are incorporated by reference.

Spinning these yarns, as well as other poly(trimethylene terephthalate) yarns and filaments, at higher speeds can be advantageous. Therefore, the ability to spin poly(trimethylene terephthalate) yarns and fibers at higher speeds is desired. It is also desired that the practitioner be able to use the resultant yarns under the same conditions as yarns prepared at slower speeds.

Use of various additives to obtain benefits in spinning or other processing steps has been described in many patents. For instance, U.S. Patent 4,475,330, which is incorporated herein by reference, discloses a high twist polyester multifilament yarn made from polyester filaments consisting essentially of (a) a copolymer of two or more monomers selected from the group consisting of ethylene terephthalate, trimethylene terephthalate and tetramethylene, and/or (b) a blend of two or more polymers of ethylene terephthalate, trimethylene terephthalate and tetramethylene terephthalate. This patent describes use of 3 to 15% of non-crystalline polymer, preferably styrene polymers or methacrylate polymers, to impart higher twist setting ability.

It is desired to increase productivity in the manufacture of poly(trimethylene terephthalate) fibers, particularly yarns such as partially oriented yarns, spun drawn yarns, and bulked continuous filament yarns, and in the manufacture of staple fibers, by using a high speed spinning process, without deterioration of the filament and yarn properties. It is further desired for these yarns to be useful in preparing products, such as textured yarns, fabrics and carpets, under the same or similar conditions to those used for poly(trimethylene terephthalate) yarns prepared at slower speeds.

SUMMARY OF THE INVENTION

This invention is directed to a process for preparing poly(trimethylene terephthalate) fiber comprising (a) providing a poly(trimethylene terephthalate) composition comprising about 0.05 to about 10 weight % ionomer and (b) spinning the polymer composition to form a fiber.

The invention is also directed to a process for preparing poly(trimethylene dicarboxylate) multifilament yarn comprising (a) providing a polymer blend comprising poly(trimethylene dicarboxylate) and about 0.1 to about 10 weight % ionomer, by weight of the polymer in the polymer blend, (b) spinning the polymer blend to form poly(trimethylene dicarboxylate) multiconstituent filaments containing dispersed ionomer, and (c) processing the multiconstituent filaments into poly(trimethylene dicarboxylate) multifilament yarn comprising poly(trimethylene dicarboxylate) multiconstituent filaments containing ionomer dispersed throughout the filaments.

Preferably the poly(trimethylene dicarboxylate) is selected from the group consisting of poly(trimethylene arylate)s and mixtures thereof. Most preferably the poly(trimethylene dicarboxylate) is poly(trimethylene terephthalate).

5 In a preferred embodiment the blend comprises about 90 to about 99.9 weight % of poly(trimethylene arylate) and about 10 to about 0.1 weight % of ionomer, by weight of the polymer in the polymer blend. More preferably the blend comprises about 95 to about 99.5 % of poly(trimethylene terephthalate) and about 2 to about 0.5 % of ionomer, by weight of the polymer in the polymer blend. Most preferably the multiconstituent filaments are poly(trimethylene
10 terephthalate) biconstituent filaments comprised of about 98 to about 99.5 % poly(trimethylene terephthalate) and about 2 to about 0.5 % ionomer, by weight of the polymer in the filaments.

In another preferred embodiment the polymer blend comprises about 70 to about 99.9 weight % of the poly(trimethylene terephthalate), about 5 to about 0.5
15 weight % of the ionomer, by weight of the polymer in the polymer blend and, optionally, up to 29.5 weight % of other polyesters, by weight of polymer in the polymer blend. Preferably the blend comprises about 2 to about 0.5 % ionomer, by weight of the polymer in the polymer blend.

Preferably the ionomer is selected from the group consisting of E/X/Y
20 copolymers where E is ethylene, X is a softening comonomer such as acrylate or methacrylate present in 0 to about 50 weight percent of the copolymer, and Y is acrylic or methacrylic acid present in about 3 to about 30 weight percent of the copolymer, and wherein the acid moiety is neutralized about 1 to about 90 % to form an ionomer by a cation selected from the group consisting of lithium,
25 sodium, potassium, magnesium, calcium, barium, lead, tin, zinc or aluminum, and combinations thereof.

More preferably the ionomer is selected from the group consisting of ethylene/acrylic acid, ethylene/methacrylic acid, ethylene/acrylic acid/n-butyl
30 acrylate, ethylene/methacrylic acid/n-butyl acrylate, ethylene/methacrylic acid/iso-butyl acrylate, ethylene/acrylic acid/iso-butyl acrylate, ethylene/methacrylic acid/n-butyl methacrylate, ethylene/acrylic acid/methyl methacrylate, ethylene/acrylic acid/methyl acrylate, ethylene/methacrylic acid/methyl acrylate, ethylene/methacrylic acid/methyl methacrylate, and ethylene/acrylic acid/n-butyl methacrylate copolymers, and mixtures thereof.

35 Even more preferably the ionomer is selected from the group consisting of ethylene/methacrylic acid, ethylene/acrylic acid, ethylene/methacrylic acid/n-

butyl acrylate, ethylene/acrylic acid/n-butyl acrylate, ethylene/methacrylic acid/methyl acrylate and ethylene/acrylic acid/methyl acrylate copolymers.

Most preferably the ionomer is selected from the group consisting of ethylene/methacrylic acid, ethylene/acrylic acid, ethylene/(meth)acrylic acid/n-butyl acrylate, ethylene/(meth)acrylic acid/ethyl acrylate, and
5 ethylene/(meth)acrylic acid/methyl acrylate copolymers.

In preferred embodiments, the blend further comprise at least one selected from the group consisting of hexamethylene diamine, polyamides, delusterants, nucleating agents, heat stabilizers, viscosity boosters, optical brighteners,
10 pigments, and antioxidants.

In one preferred embodiment, the multifilament yarn is partially oriented yarn and the spinning comprises extruding the polymer blend through a spinneret at a spinning speed of at least about 3,000 m/m. When the multifilament yarns comprise about 0.5 to about 2.5 dpf filaments, they are preferably spun at a
15 spinning speed of at least about 2,500 m/m. Preferably the processing comprises interlacing and winding the filaments.

In another preferred embodiment, the multifilament yarn is spun drawn yarn and the processing comprises drawing the filaments at a draw speed, as measured at the roller at the end of the draw step, of about 2,000 to about 8,000
20 m/m. Preferably, spun drawn poly(trimethylene terephthalate) multifilament yarn process comprises drawing, annealing, interlacing and winding the filaments.

In yet another preferred embodiment, the multifilament yarn is bulked continuous filament yarn, and preferably the processing comprises drawing, annealing, bulking, entangling (which can be carried out in one step with bulking or in a subsequent separate step), optionally relaxing, and winding the filaments.
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In a further preferred embodiment, the process further comprises cutting the multifilament yarn into staple fibers.

A process for preparing poly(trimethylene terephthalate) multifilament textured yarn comprising poly(trimethylene terephthalate) multiconstituent
30 filaments, comprising (a) preparing a package of partially oriented poly(trimethylene terephthalate) multifilament yarn, (b) unwinding the yarn from the package, (c) drawing the multiconstituent filaments yarn to form a drawn yarn, (d) false-twist texturing the drawn yarn to form the textured yarn, and (e) winding the yarn onto a package.

35 The invention is also directed to a process for preparing poly(trimethylene terephthalate) multifilament textured yarn comprising poly(trimethylene terephthalate) multiconstituent filaments, comprising (a) preparing a package of

spun drawn poly(trimethylene terephthalate) multifilament yarn, (b) unwinding the yarn from the package, (c) false-twist texturing the yarn to form the textured yarn, and (d) winding the textured yarn onto a package.

5 Preferably the ionomer is highly dispersed throughout the fiber or filaments, or in the case of a multicomponent fiber the component(s).

Preferably the ionomer is substantially uniformly dispersed throughout the fiber or filaments, or in the case of a multicomponent fiber the component(s).

The invention is also directed to a process for preparing a poly(trimethylene dicarboxylate) monofilament comprising (a) providing a
10 polymer blend comprising poly(trimethylene dicarboxylate) and about 0.1 to about 10 weight % ionomer, by weight of the polymer in the polymer blend, (b) spinning the polymer blend to form poly(trimethylene dicarboxylate) monofilament containing dispersed ionomer, and (c) processing the filament into poly(trimethylene dicarboxylate) multiconstituent monofilament comprising
15 poly(trimethylene dicarboxylate) ionomer dispersed throughout.

A poly(trimethylene terephthalate) fiber comprising poly(trimethylene terephthalate) with about 0.1 to about 10 weight % ionomer dispersed throughout the poly(trimethylene terephthalate).

20 In addition, the invention is directed to a poly(trimethylene terephthalate) fiber comprising containing about 0.1 to about 10 weight % ionomer dispersed throughout the fiber, as well as multicomponent and bicomponent fibers with at least one component containing about 0.1 to about 10 weight % ionomer dispersed throughout the component, and yarns and other products therefrom.

The invention is further directed to a poly(trimethylene terephthalate) yarn
25 comprising poly(trimethylene terephthalate) multiconstituent filament containing about 0.1 to about 10 weight % ionomer dispersed throughout the multiconstituent filament, and fabrics and carpets prepared therefrom.

This invention is also directed to the poly(trimethylene terephthalate) blends described above. In addition to being useful in fibers, such blends are
30 useful in other shaped articles, such as films, film layers, bottles, sheets, engineering polymer components, etc.

Other preferences are described below.

The invention enables the practitioner to increase productivity in the spinning of poly(trimethylene terephthalate) fibers, particularly partially oriented
35 yarns, spun drawn yarns, bulked continuous filament yarns and staple fiber manufacture, by using a high spinning speed process. Surprisingly, the resultant fibers are useful in preparing products, such as textured yarns, fabrics and carpets,

under the same or similar conditions to those used for poly(trimethylene terephthalate) fibers prepared at slower speeds. In addition, it has been found that the ionomer uniformly dispersed throughout the fibers, and yarns can be prepared and used at high speeds, are stable, have good physical properties, and can be dyed uniformly. Other results are described below.

DETAILED DESCRIPTION OF THE INVENTION

A process has been developed to produce poly(trimethylene dicarboxylate) fibers, particularly partially oriented yarns, at high spin speeds. The advantages of the invention are obtained using a blend comprising poly(trimethylene dicarboxylate) and ionomer.

The preferred poly(trimethylene dicarboxylate)s are the poly(trimethylene arylate)s. Examples are poly(trimethylene terephthalate), poly(trimethylene naphthalate), poly(trimethylene isophthalate). Most preferred is poly(trimethylene terephthalate) and, for convenience, this document will refer to poly(trimethylene terephthalate), from which the person of ordinary skill in the art will readily recognize how to apply the invention to other poly(trimethylene dicarboxylates).

In the absence of an indication to the contrary, a reference to "poly(trimethylene terephthalate)" ("3GT" or "PTT"), is meant to encompass homopolymers and copolymers containing at least 70 mole % trimethylene terephthalate repeat units and polymer blends containing at least 70 mole % or the homopolymers or copolyesters. The preferred poly(trimethylene terephthalate)s contain at least 85 mole %, more preferably at least 90 mole %, even more preferably at least 95 or at least 98 mole %, and most preferably about 100 mole %, trimethylene terephthalate repeat units.

Examples of copolymers include copolyesters made using 3 or more reactants, each having two ester forming groups. For example, a copoly(trimethylene terephthalate) can be used in which the comonomer used to make the copolyester is selected from the group consisting of linear, cyclic, and branched aliphatic dicarboxylic acids having 4-12 carbon atoms (for example butanedioic acid, pentanedioic acid, hexanedioic acid, dodecanedioic acid, and 1,4-cyclo-hexanedicarboxylic acid); aromatic dicarboxylic acids other than terephthalic acid and having 8-12 carbon atoms (for example isophthalic acid and 2,6-naphthalenedicarboxylic acid); linear, cyclic, and branched aliphatic diols having 2-8 carbon atoms (other than 1,3-propanediol, for example, ethanediol, 1,2-propanediol, 1,4-butanediol, 3-methyl-1,5-pentanediol, 2,2-dimethyl-1,3-propanediol, 2-methyl-1,3-propanediol, and 1,4-cyclohexanediol); and aliphatic

and aromatic ether glycols having 4-10 carbon atoms (for example, hydroquinone bis(2-hydroxyethyl) ether, or a poly(ethylene ether) glycol having a molecular weight below about 460, including diethyleneether glycol). The comonomer typically is present in the copolyester at a level in the range of about 0.5 - about 5 15 mole %, and can be present in amounts up to 30 mole %.

The poly(trimethylene terephthalate) can contain minor amounts of other comonomers, and such comonomers are usually selected so that they do not have a significant adverse affect on properties. Such other comonomers include 5- sodium-sulfoisophthalate, for example, at a level in the range of about 0.2 to 5 10 mole %. Very small amounts of trifunctional comonomers, for example trimellitic acid, can be incorporated for viscosity control.

The poly(trimethylene terephthalate) can be blended with up to 30 mole percent of other polymers. Examples are polyesters prepared from other diols, such as those described above. The preferred poly(trimethylene terephthalate)s 15 contain at least 85 mole %, more preferably at least 90 mole %, even more preferably at least 95 or at least 98 mole %, and most preferably about 100 mole %, poly(trimethylene terephthalate) polymer.

The intrinsic viscosity of the poly(trimethylene terephthalate) of the invention is at least about 0.70 dl/g, preferably at least about 0.80 dl/g, more 20 preferably at least about 0.90 dl/g and most preferably at least about 1.0 dl/g. The intrinsic viscosity of the polyester composition of the invention are preferably up to about 2.0 dl/g, more preferably up to 1.5 dl/g, and most preferably up to about 1.2 dl/g.

The number average molecular weight (Mn) for poly(trimethylene terephthalate) is preferably at least about 10,000, more preferably at least about 20,000, and is preferably about 40,000 or less, more preferably about 25,000 or less. The preferred Mn depends on the poly(trimethylene terephthalate) used and any additives or modifiers present in the blend, as well as the properties of the ionomer.

30 Poly(trimethylene terephthalate) and preferred manufacturing techniques for making poly(trimethylene terephthalate) are described in U.S. Patent Nos. 5,015,789, 5,276,201, 5,284,979, 5,334,778, 5,364,984, 5,364,987, 5,391,263, 5,434,239, 5,510,454, 5,504,122, 5,532,333, 5,532,404, 5,540,868, 5,633,018, 5,633,362, 5,677,415, 5,686,276, 5,710,315, 5,714,262, 5,730,913, 5,763,104, 35 5,774,074, 5,786,443, 5,811,496, 5,821,092, 5,830,982, 5,840,957, 5,856,423, 5,962,745, 5,990,265, 6,235,948, 6,245,844, 6,255,442, 6,277,289, 6,281,325, 6,312,805, 6,325,945, 6,331,264, 6,335,421, 6,350,895, and 6,353,062,

EP 998 440, WO 00/14041 and 98/57913, H. L. Traub, "Synthese und
textilchemische Eigenschaften des Poly-Trimethyleneterephthalats", Dissertation
Universität Stuttgart (1994), S. Schauhoff, "New Developments in the Production
of Poly(trimethylene terephthalate) (PTT)", Man-Made Fiber Year Book
5 (September 1996), and U.S. 6,538,076, all of which are incorporated herein by
reference. Poly(trimethylene terephthalate)s useful as the polyester of this
invention are commercially available from E. I. du Pont de Nemours and
Company, Wilmington, Delaware (DuPont), under the trademark Sorona.

Conventional polyethylene-based ionomers, such as SURLYN[®] ionomer
10 available from DuPont, are useful in this invention. Such ionomers are obtained
by providing thermolabile ionic crosslinking to polymers of monoolefin with at
least one member selected from the group consisting of unsaturated mono- or di-
carboxylic acids having 3 to 12 carbon atoms and esters thereof (the polymer
contains 1 to 50% by weight of the unsaturated mono- or di-carboxylic acid
15 and/or ester thereof). More particularly, such acid- containing ethylene
copolymer ionomer component includes E/X/Y copolymers where E is ethylene,
X is a softening comonomer such as acrylate or methacrylate present in 0 to about
50 (preferably 0 to about 25, most preferably 0 to about 20), weight percent of the
polymer, and Y is acrylic or methacrylic acid present in about 3 to about 30
20 (preferably about 5 to about 20) weight percent of the polymer, wherein the acid
moiety is neutralized about 1 to about 90% (preferably at least about 40%, most
preferably at least about 60%) to form an ionomer by a cation such as lithium,
sodium, potassium, magnesium, calcium, barium, lead, tin, zinc or aluminum, or a
combination of such cations. Specific acid- containing ethylene copolymers
25 include ethylene/acrylic acid, ethylene/methacrylic acid, ethylene/acrylic acid/n-
butyl acrylate, ethylene/methacrylic acid/n-butyl acrylate, ethylene/methacrylic
acid/iso- butyl acrylate, ethylene/acrylic acid/iso-butyl acrylate,
ethylene/methacrylic acid/n-butyl methacrylate, ethylene/acrylic acid/methyl
methacrylate, ethylene/acrylic acid/methyl acrylate, ethylene/methacrylic
30 acid/methyl acrylate, ethylene/methacrylic acid/methyl methacrylate, and
ethylene/acrylic acid/n-butyl methacrylate. Preferred acid-containing ethylene
copolymers include ethylene/methacrylic acid, ethylene/acrylic acid,
ethylene/methacrylic acid/n-butyl acrylate, ethylene/acrylic acid/n-butyl acrylate,
ethylene/methacrylic acid/methyl acrylate and ethylene/acrylic acid/methyl
35 acrylate copolymers. The most preferred acid-containing ethylene copolymers are
ethylene/methacrylic acid, ethylene/acrylic acid, ethylene/(meth)acrylic acid/n-

butyl acrylate, ethylene/(meth)acrylic acid/ethyl acrylate, and ethylene/(meth)acrylic acid/methyl acrylate copolymers.

5 Ionomers and the manner in which the ionomers are made is well known in the art as described in, e.g., U.S. Patent No. 3,262,272, Encyclopedia of Polymer Science and Engineering, "Ionic Polymers", Volume 8, pp. 393-423 (1985), and Encyclopedia of Chemical Technology, "Ionomers", Volume 14, pp. 815-829 (Fourth Edition, 1995).

10 In a preferred embodiment, the fibers are prepared with styrene polymers as described in U.S. Patent Application No. 10/183,710, filed June 27, 2002 (Attorney Docket # CH2784), which is incorporated herein by reference.

By "styrene polymer" is meant polystyrene and its derivatives. Preferably the styrene polymer is selected from the group consisting of polystyrene, alkyl or aryl substituted polystyrenes and styrene multicomponent polymers. Here, "multicomponent" includes copolymers, terpolymers, tetrapolymers, etc., and
15 blends.

More preferably the styrene polymer is selected from the group consisting of polystyrene, alkyl or aryl substituted polystyrenes prepared from α -methylstyrene, p-methoxystyrene, vinyltoluene, halostyrene and dihalostyrene (preferably chlorostyrene and dichlorostyrene), styrene-butadiene copolymers and
20 blends, styrene-acrylonitrile copolymers and blends, styrene-acrylonitrile-butadiene terpolymers and blends, styrene-butadiene-styrene terpolymers and blends, styrene-isoprene copolymers, terpolymers and blends, and blends and mixtures thereof. Even more preferably, the styrene polymer is selected from the group consisting of polystyrene, methyl, ethyl, propyl, methoxy, ethoxy, propoxy
25 and chloro-substituted polystyrene, or styrene-butadiene copolymer, and blends and mixtures thereof. Yet more preferably, the styrene polymer is selected from the group consisting of polystyrene, α -methyl-polystyrene, and styrene-butadiene copolymers and blends thereof. Most preferably, the styrene polymer is polystyrene.

30 The number average molecular weight of the styrene polymer is at least about 5,000, preferably at least 50,000, more preferably at least about 75,000, even more preferably at least about 100,000 and most preferably at least about 120,000. The number average molecular weight of the styrene polymer is preferably up to about 300,000, more preferably up to about 200,000 and most
35 preferably up to about 150,000.

Useful polystyrenes can be isotactic, atactic, or syndiotactic, and with high molecular weight polystyrenes atactic is preferred. Styrene polymers useful in

this invention are commercially available from many suppliers including Dow Chemical Co. (Midland, MI), BASF (Mount Olive, NJ) and Sigma-Aldrich (Saint Louis, MO).

In one preferred embodiment, the poly(trimethylene terephthalate) composition preferably comprises at least about 0.1 %, more preferably at least about 0.5 %, of styrene polymer, by weight of the polymer in the poly(trimethylene terephthalate) composition. It preferably comprises up to about 10 %, more preferably up to about 5 %, even more preferably up to about 2 %, and most preferably up to about 1.5 %, of a styrene polymer, by weight of the polymer in the poly(trimethylene terephthalate) composition. In many instances, preferred is about 0.8% to about 1% styrene polymer, by weight of the polymer in the poly(trimethylene terephthalate) composition. Reference to styrene polymer means at least one styrene polymer, as two or more styrene polymers can be used, and the amount referred to is an indication of the total amount of styrene polymer(s) used in the poly(trimethylene terephthalate) composition.

In a preferred embodiment, the fibers are prepared with poly(trimethylene terephthalate) containing about 0.05 to about 5 mole % tetramethylene terephthalate repeat units as described in U.S. Patent Application No. 10/193,498, filed July 11, 2002 (Attorney Docket # SO-0012), which is incorporated herein by reference. These fibers can also contain styrene polymer as described above and in U.S. Patent Application No. 10/193,498, filed July 11, 2002 (Attorney Docket # SO-0012), which is incorporated herein by reference.

In this embodiment, tetramethylene terephthalate repeat units are present in the poly(trimethylene terephthalate) composition in amount of at least about 0.05 mole %, preferably at least about 0.1 mole %, more preferably at least about 0.5 mole %, even more preferably at least about 0.6 mole %, even more preferably at least about 0.75 mole %, even more preferably at least about 0.9 mole %, even more preferably at least about 1 mole %, even more preferably greater than 1 mole %, even more preferably at least about 1 mole %, even more preferably at least about 1.5 mole %, and most preferably greater than 1.5 mole %, of poly(tetramethylene terephthalate). Tetramethylene terephthalate repeat units are present in an amount of up to about 5 mole %, preferably less than 5 mole %, more preferably up to 4.5 mole %, even more preferably less than 4 mole %, even more preferably up to about 3 mole %, even more preferably less than 3 mole %, most preferably up to about 2.5 mole %, of poly(tetramethylene terephthalate). Most preferred is about 2 mole % of poly(tetramethylene terephthalate). They can

be in the form of poly(tetramethylene terephthalate) and/or poly(trimethylene terephthalate) copolyester resulting from transesterification or added.

In many instances, the polymer blend will be prepared from poly(tetramethylene terephthalate) homopolymers or polymers that only contain
5 minor amounts of other repeat units. In that instance reference to poly(tetramethylene terephthalate) being added in amount of at least about 0.05 to about 5 mole %, with the preferences indicated above, is appropriate.

Poly(trimethylene terephthalate) and poly(tetramethylene terephthalate) can undergo transesterification under heat, so that some or all of the
10 poly(tetramethylene terephthalate) will react with the poly(trimethylene terephthalate) to form a copolyester. Therefore, the resulting product can be described as poly(trimethylene terephthalate) copolyester containing tetramethylene terephthalate repeating units in an amount within the ranges described above (e.g., about 0.05 to about 5 mole %).

15 When referring to the mole percentage of a trimethylene or tetramethylene terephthalate repeat unit, reference is to the individual repeat unit rather than blocks of repeat units.

Any commercially available poly(tetramethylene terephthalate) should be useful in this invention. Preferred poly(tetramethylene terephthalate)s have an
20 intrinsic viscosity of about 0.6 to about 1.5 dl/g.

The poly(tetramethylene terephthalate) can also contain other repeat units, such as described above for poly(trimethylene terephthalate), as the most important factor is the total number of tetramethylene terephthalate repeat units in the composition.

25 The repeat unit molecular weight ratio of trimethylene terephthalate repeat units to tetramethylene terephthalate repeat units is 0.94. Therefore, the weight % of tetramethylene terephthalate repeat units can be calculated by multiplying the mole % by 0.94.

The invention can also be practiced by starting with poly(trimethylene
30 terephthalate) copolyesters containing about 0.05 to about 5 mole % tetramethylene terephthalate units, preferably in the amounts described above with respect to poly(trimethylene terephthalate)/poly(tetramethylene terephthalate) blends. Here, "copolyesters" is used with reference to polyesters that can have two or more components, provided that the total trimethylene terephthalate repeat
35 units and tetramethylene terephthalate repeat units are in the ranges described herein. The copolyesters can be block or random copolyesters, and can be prepared by known condensation polymerization techniques.

The polymer blend comprises poly(trimethylene terephthalate) and a styrene polymer. In some cases these will be the only two items in the blend and they will total 100 weight %. However, in many instances the blend will have other ingredients, such as other polymers, additives, etc., and thus the total of the poly(trimethylene terephthalate) and polystyrene will not be 100 weight %.

The poly(trimethylene terephthalate) composition preferably comprises at least about 70%, more preferably at least about 80 %, even more preferably at least 85 %, more preferably at least about 90 %, most preferably at least about 95 %, and in some cases even more preferably at least 98 % of poly(trimethylene terephthalate) and poly(tetramethylene terephthalate), and/or the copolyester (by weight of the polymer in the poly(trimethylene terephthalate) composition). It preferably contains up to about 99.9 % of poly(trimethylene terephthalate) and poly(tetramethylene terephthalate), and/or copolyester.

The poly(trimethylene terephthalate) can also be an acid-dyeable polyester composition as described in U.S. Patent No. 6,576,340 (corresponding to WO 01/34693) or U.S. Patent Publication No. 2003/0083441 A1, both of which are incorporated herein by reference. The poly(trimethylene terephthalate)s of U.S. Patent No. 6,576,340 comprise a secondary amine or secondary amine salt in an amount effective to promote acid-dyeability of the acid dyeable and acid dyed polyester compositions. Preferably, the secondary amine unit is present in the polymer composition in an amount of at least about 0.5 mole %, more preferably at least 1 mole %. The secondary amine unit is present in the polymer composition in an amount preferably of about 15 mole % or less, more preferably about 10 mole % or less, and most preferably 5 mole % or less, based on the weight of the composition. The acid-dyeable poly(trimethylene terephthalate) compositions of U.S. Patent Publication No. 2003/0083441 A1 comprise poly(trimethylene terephthalate) and a polymeric additive based on a tertiary amine. The polymeric additive is prepared from (i) triamine containing secondary amine or secondary amine salt unit(s) and (ii) one or more other monomer and/or polymer units. One preferred polymeric additive comprises polyamide selected from the group consisting of poly-imino-bisalkylene-terephthalamide, -isophthalamide and -1,6-naphthalamide, and salts thereof. The poly(trimethylene terephthalate) useful in this invention can also cationically dyeable or dyed composition such as those described in U.S. Patent No. 6,312,805, granted November 6, 2001, which is incorporated herein by reference, and dyed or dye-containing compositions.

Other polymeric additives can be added to the poly(trimethylene terephthalate), ionomer, poly(tetramethylene terephthalate), copolyester, styrene polymer, polymer blend, etc., to improve strength, to facilitate post extrusion processing or provide other benefits. For example, hexamethylene diamine can be added in minor amounts of about 0.5 to about 5 mole % to add strength and processability to the acid dyeable polyester compositions of the invention. Polyamides such as Nylon 6 or Nylon 6-6 can be added in minor amounts of about 0.5 to about 5 mole % to add strength and processability to the acid-dyeable polyester compositions of the invention. A nucleating agent, preferably 0.005 to 2 weight % of a mono-sodium salt of a dicarboxylic acid selected from the group consisting of monosodium terephthalate, mono sodium naphthalene dicarboxylate and mono sodium isophthalate, as a nucleating agent, can be added as described in U.S. 6,245,844, which is incorporated herein by reference.

The poly(trimethylene terephthalate), ionomer, poly(tetramethylene terephthalate), styrene polymer, mixture or blend, etc., can, if desired, contain additives, e.g., delusterants, nucleating agents, heat stabilizers, viscosity boosters, optical brighteners, pigments, and antioxidants. TiO₂ or other pigments can be added to the poly(trimethylene terephthalate), the blend, or in fiber manufacture. (See, e.g., U.S. Patent Nos. 3,671,379, 5,798,433 and 5,340,909, EP 699 700 and 847 960, and WO 00/26301, which are incorporated herein by reference.)

The polymer blend can be provided by any known technique, including physical blends and melt blends. Preferably the poly(trimethylene terephthalate) and ionomer are melt blended and compounded. More specifically, poly(trimethylene terephthalate) and ionomer are mixed and heated at a temperature sufficient to form a blend, and upon cooling, the blend is formed into a shaped article, such as pellets. The poly(trimethylene terephthalate) and polystyrene can be formed into a blend in many different ways. For instance, they can be (a) heated and mixed simultaneously, (b) pre-mixed in a separate apparatus before heating, or (c) heated and then mixed. As an example, the polymer blend can be made by transfer line injection. The mixing, heating and forming can be carried out by conventional equipment designed for that purpose such as extruders, Banbury mixers or the like. The temperature should be above the melting points of each component but below the lowest decomposition temperature, and accordingly must be adjusted for any particular composition of poly(trimethylene terephthalate) and polystyrene. Temperature is typically in the range of about 200°C to about 270°C, most preferably at least about 250°C and

preferably up to about 260°C, depending on the particular polystyrene composition of the invention.

In one preferred embodiment, poly(trimethylene terephthalate), ionomer, and, optionally, other ingredients such as styrene polymer or poly(tetramethylene terephthalate), are melt blended and, then, extruded and cut into pellets. ("Pellets" is used generically in this regard, and is used regardless of shape so that it is used to include products sometimes called "chips", "flakes", etc.) The pellets are then remelted and extruded into filaments. The term "mixture" is used to refer to the pellets prior to remelting and the term "blend" is used to refer to them once they have been remelted. In considering the discussion of the relative amounts of poly(trimethylene terephthalate), ionomer poly(tetramethylene terephthalate), styrene polymer and other items described herein the same percentages apply to both the mixture and blend, although it will readily be recognized that various methods of preparing filaments can entail items being added to the mixture or blend, and therefore in some facilities the percentages can vary, but the ratio of the polymers should remain the same. For convenience, reference herein will be to the amount of polymer in the blend except where the specific reference is to the mixture before remelt.

By "multiconstituent fibers" is meant a fiber formed from at least two polymers, one of which forms a continuous phase and the others being in one or more discontinuous phases dispersed throughout the fiber, wherein the at least two polymers are extruded from the same extruder as a blend. The ionomer, and separately the optional styrene polymer(s), form a discontinuous phase and is (are) highly dispersed throughout the filaments. The ionomer and, when present the styrene polymer, can be seen to be substantially uniformly dispersed throughout the fibers. "Biconstituent" is used to refer to the case where the only polymer phases are the poly(trimethylene terephthalate) and ionomer. Specifically excluded from this definition are bicomponent and multicomponent fibers, such as sheath core or side-by-side fibers made of two different types of polymers or two of the same polymer having different characteristics in each region. (This definition does not exclude other polymers being dispersed in the fiber, and additives and ingredients being present.) However, the invention can also be practiced with multicomponent fibers, such as bicomponent fibers, including sheath/core bicomponent fibers with ionomer in the sheath and/or core, side-by-side bicomponent fibers with the ionomer in one or both sides, islands in the sea fibers, etc.

The ionomer and, when present the styrene polymer, is highly dispersed throughout the poly(trimethylene terephthalate) polymer matrix.

Partially oriented yarns of poly(trimethylene terephthalate) are described in U.S. Patent Nos. 6,287,688 and 6,333,106, and U.S. Patent Publication No. 2001/0030378, all of which are incorporated herein by reference. The basic steps of manufacturing partially oriented yarns including spinning, interlacing and winding poly(trimethylene terephthalate) filaments are described therein. This invention can be practiced using those steps or other steps conventionally used for making partially oriented polyester yarns; however, it provides the advantage of carrying out the process at higher speeds.

Preferably, prior to spinning a blend is heated to a temperature above the melting point of each the poly(trimethylene terephthalate) and ionomer (as well as styrene polymer and 4GT when present), and extruding the blend through a spinneret and at a temperature of about 235 to about 295°C, preferably at least about 250°C and preferably up to about 290 °C, most preferably up to about 270°C.

The partially oriented yarns are multifilament yarns. The yarns (also known as "bundles") preferably comprise at least about 10 and even more preferably at least about 25 filaments, and typically can contain up to about 150 or more, preferably up to about 100, more preferably up to about 80 filaments. Yarns containing 34, 48, 68 or 72 filaments are common. The yarns typically have a total denier of at least about 5, preferably at least about 20, preferably at least about 50, and up to about 1,500 or more, preferably up to about 250.

Filaments are preferably at least about 0.5 dpf, more preferably at least about 1 dpf, and up to about 10 or more dpf, more preferably up to about 7 dpf. Typical filaments are about 3 to about 7 dpf, and fine filaments are about 0.5 to about 2.5 dpf.

Spin speeds can run from about 1,800 to about 8,000 or more meters/minute ("m/m"), and are preferably at least about 2,000 m/m, more preferably at least about 2,500 m/m, and most preferably at least about 3,000 m/m. One advantage of this invention is that partially oriented yarns of poly(trimethylene terephthalate) can be spun on equipment previously used to spin partially oriented yarns of poly(ethylene terephthalate), so spin speeds are preferably up to about 4,000 m/m, more preferably up to about 3,500 m/m. Spinning speeds of about 3,200 m/m frequently used to spin partially oriented yarns of poly(trimethylene terephthalate) are preferred.

The invention is primarily discussed with typical about 3 to about 7 dpf filaments. Spin speeds for fine filaments are lower. For instance, poly(trimethylene terephthalate) multifilament yarns of fine filaments are presently spun at less than 2,000 m/m, whereas with the invention they can be spun at higher speeds, such as about 2,500 m/m or higher.

Partially oriented yarns are usually wound on a package, and can be used to make fabrics or further processed into other types of yarn, such as textured yarn. They can also be stored in a can prior to preparing fabrics or further processing, or can be used directly without forming a package or other storage.

Spun drawn yarn, also known as "fully drawn yarn", can also be prepared advantageously using the invention. The preferred steps of manufacturing spun drawn yarns including spinning, drawing, optionally and preferably annealing, optionally interlacing, and winding poly(trimethylene terephthalate) filaments are similar to those used for preparing poly(ethylene terephthalate) yarns.

One advantage of this invention is that the process can be carried out at higher speeds than when the polymers of this invention aren't used.

Another advantage of this invention is that spun drawn yarns can be prepared using higher draw ratios than with poly(trimethylene terephthalate) by itself. This can be done by using a lower spin speed than normal, and then drawing at previously used speeds. When carrying out this process, there are fewer breaks than previously encountered.

Preferably, prior to spinning a blend is heated to a temperature above the melting point of each the poly(trimethylene terephthalate) and ionomer (as well as styrene polymer or 4GT when present), and extruding the blend through a spinneret and at a temperature of about 235 to about 295°C, preferably at least about 250°C and up to about 290°C, most preferably up to about 270°C.

These yarns are also multifilament yarns. The yarns (also known as "bundles") preferably comprise at least about 10 and even more preferably at least about 25 filaments, and typically can contain up to about 150 or more, preferably up to about 100, more preferably up to about 80 filaments. Yarns containing 34, 48, 68 or 72 filaments are common. The yarns typically have a total denier of at least about 5, preferably at least about 20, preferably at least about 50, and up to about 1,500 or more, preferably up to about 250.

Filaments are preferably at least about 0.1 dpf, more preferably at least about 0.5 dpf, more preferably at least about 0.8 dpf, and up to about 10 or more dpf, more preferably up to about 5 dpf, and most preferably up to about 3 dpf.

The draw ratio is at least 1.01, preferably at least about 1.2 and more preferably at least about 1.3. The draw ratio is preferably up to about 5, more preferably up to about 3, and most preferably up to about 2.5.

5 Draw speeds (as measured at the roller at the end of the draw step) can run from about 2,000 or more m/m, and are preferably at least about 3,000 m/m, more preferably at least about 3,200 m/m, and preferably up to about 8,000 m/m, more preferably up to about 7,000 m/m.

Spun drawn yarns are usually wound on a package, and can be used to make fabrics or further processed into other types of yarn, such as textured yarn.
10 They can also be stored in a can prior to preparing fabrics or further processing, or can be used directly without forming a package or other storage.

Textured yarns can be prepared from partially oriented yarns or spun drawn yarns. The main difference is that the partially oriented yarns usually require drawing whereas the spun drawn yarns are already drawn.

15 U.S. Patent Nos. 6,287,688 and 6,333,106, and U.S. Patent Publication No. 2001/0030378 A1, all of which are incorporated herein by reference, describe the basic steps of manufacturing textured yarns from partially oriented yarns. This invention can be practiced using those steps or other steps conventionally used for making partially oriented polyester yarns. The basic steps include unwinding the
20 yarns from a package, drawing, twisting, heat-setting, untwisting, and winding onto a package. Texturing imparts crimp by twisting, heat setting, and untwisting by the process commonly known as false twist texturing. The false-twist texturing is carefully controlled to avoid excessive yarn and filament breakage.

A preferred process for friction false-twisting described in U.S. Patent
25 Nos. 6,287,688 and 6,333,106, and U.S. Patent Publication No. 2001/0030378 A1 comprises heating the partially oriented yarn to a temperature between 140°C and 220°C, twisting the yarn using a twist insertion device such that in the region between the twist insertion device and the entrance of the heater, the yarn has a twist angle of about 46° to 52° and winding the yarn on a winder.

30 When prepared from spun drawn yarn, the process is the same except that drawing is reduced to a very low level (e.g., draw ratio can be as low as 1.01).

These multifilament yarns (also known as "bundles") comprise the same number of filaments as the partially oriented yarns and spun drawn yarns from which they are made. Thus, they preferably comprise at least about 10 and even
35 more preferably at least about 25 filaments, and typically can contain up to about 150 or more, preferably up to about 100, more preferably up to about 80 filaments. The yarns typically have a total denier of at least about 1, more

preferably at least 20, preferably at least about 50, and up to about 1,500 or more, preferably up to about 250.

Filaments are preferably at least about 0.1 dpf, more preferably at least about 0.5 dpf, more preferably at least about 0.8 dpf, and up to about 10 or more dpf, more preferably up to about 5 dpf, and most preferably up to about 3 dpf.

When prepared from partially oriented yarn, the draw ratio is at least 1.01, preferably at least about 1.2 and more preferably at least about 1.3. The draw ratio is preferably up to about 5, more preferably up to about 3, and most preferably up to about 2.5. Draw speeds (as measured at the roller at the end of the draw step) can run from about 50 to about 1,200 or more m/m, and are preferably at least about 300 m/m and preferably up to about 1,000 m/m.

When prepared from spun drawn yarns, speeds (as measured at the first godet the fiber contacts) can run from about 50 to about 1,200 or more m/m, and are preferably at least about 300 m/m and preferably up to about 800 m/m.

A major advantage of this invention is that textured yarns can be prepared under the same or similar operating conditions to those used for partially oriented or spun drawn poly(trimethylene terephthalate) yarns prepared at slower conditions.

Poly(trimethylene terephthalate) bulked continuous filament ("BCF") yarns and their manufacture are described in U.S. Patent Nos. 5,645,782 Howell et al., 6,109,015 Roark et al. and 6,113,825 Chuah; U.S. Patent No. 6,576,340; U.S. Published Patent Nos. 2003/00455611 A1 and 2003/0083441 A1; and U.S. Patent Application 10/099,373 (Attorney Docket No. CH2848); and WO 99/19557, all of which are incorporated herein by reference. BCF yarns are used to prepare all types of carpets, as well as textiles. The compositions of this invention can be used to improve the spin speed of their preparation.

Preferred steps involved in preparing bulked continuous filaments include spinning (e.g., extruding, cooling and coating (spin finish) the filaments), single stage or multistage drawing (preferably with heated rolls, heated pin or hot fluid assist (e.g., steam or air)) at about 80 to about 200°C and at a draw ratio of about 3 to about 5, preferably at least about 3.4 and preferably up to about 4.5, annealing at a temperature of about 120 to about 200°C, bulking, entangling (which can be carried out in one step with bulking or in a subsequent separate step) optionally relaxing, and winding the filaments on a package for subsequent use.

Bulked continuous filament yarns can be made into carpets using well known techniques. Typically, a number of yarns are cable twisted together and

heat set in a device such as an autoclave, Suessen or Superba[®], and then tufted into a primary backing. Latex adhesive and a secondary backing are then applied.

A major advantage of this invention is that carpets can be prepared under the same or similar operating conditions to those used for poly(trimethylene terephthalate) bulked continuous filament yarns prepared at slower conditions.

Another advantage of the invention is that the draw ratio does not need to be lowered due to the use of a higher spinning speed. That is, poly(trimethylene terephthalate) orientation is normally increased when spinning speed is increased. With higher orientation, the draw ratio normally needs to be reduced. With this invention, the poly(trimethylene terephthalate) orientation is lowered as a result of using the styrene polymer, so the practitioner is not required to use a lower draw ratio.

Staple fibers and products can be prepared using the processes described in U.S. Published Patent Nos. 2002/0071951 A1 and 2002/0153641 A1, WO 01/68962, WO 01/76923, and WO 02/22927, which are incorporated herein by reference. Poly(trimethylene dicarboxylate) staple fibers can be prepared by melt spinning the poly(trimethylene dicarboxylate) - ionomer blend at a temperature of about 245 to about 285°C into filaments, quenching the filaments, drawing the quenched filaments, crimping the drawn filaments, and cutting the filaments into staple fibers, preferably having a length of about 0.2 to about 6 inches (about 0.5 to about 15 cm).

One preferred process comprises: (a) providing a polymer blend comprising poly(trimethylene dicarboxylate) and about 10 to about 0.1 % ionomer, (b) melt spinning the melted blend at a temperature of about 245 to about 285°C into filaments, (c) quenching the filaments, (d) drawing the quenched filaments, (e) crimping the drawn filaments using a mechanical crimper at a crimp level of about 8 to about 30 crimps per inch (about 3 to about 12 crimps/cm), (f) relaxing the crimped filaments at a temperature of about 50 to about 120°C, and (g) cutting the relaxed filaments into staple fibers, preferably having a length of about 0.2 to about 6 inches (about 0.5 to about 15 cm). In one preferred embodiment of this process, the drawn filaments are annealed at about 85 to about 115°C before crimping. Preferably, annealing is carried out under tension using heated rollers. In another preferred embodiment, the drawn filaments are not annealed before crimping.

Staple fibers are useful in preparing textile yarns and textile or nonwoven fabrics, and can also be used for fiberfill applications and making carpets.

The invention can also be used to prepare monofilaments. Preferably monofilaments are 10 to 200 dpf. Monofilaments, monofilament yarns and use thereof are described in U.S. 5,340,909, EP 1 167 594 and WO 2001/75200, which are incorporated herein by reference. While the invention is primarily described with respect to multifilament yarns, it should be understood that the preferences described herein are applicable to monofilaments.

The filaments can be round or have other shapes, such as octalobal, delta, sunburst (also known as sol), scalloped oval, trilobal, tetra-channel (also known as quatra-channel), scalloped ribbon, ribbon, starburst, etc. They can be solid, hollow or multi-hollow.

While it is possible to prepare more than one type of yarn using a spinneret, the invention is preferably practiced by spinning one type of filament using a spinneret.

This invention is also directed to the poly(trimethylene terephthalate) blends described above. In addition to being useful in fibers, such blends are useful in other shaped articles, such as films, film layers, bottles, sheets, engineering polymer components, etc.

EXAMPLES

The following examples are presented for the purpose of illustrating the invention, and are not intended to be limiting. All parts, percentages, etc., are by weight unless otherwise indicated.

Intrinsic Viscosity

The intrinsic viscosity (IV) was determined using viscosity measured with a Viscotek Forced Flow Viscometer Y900 (Viscotek Corporation, Houston, TX) for the poly(trimethylene terephthalate) dissolved in 50/50 weight % trifluoroacetic acid/methylene chloride at a 0.4 grams/dL concentration at 19°C following an automated method based on ASTM D 5225-92. These measured IV values were correlated to IV values measured manually in 60/40 weight % phenol/1,1,2,2-tetrachloroethane following ASTM D 4603-96.

Melt Index

Melt Index (g/10 min) was measured using ASTM 1238, 200°C/5 kg.

Tenacity and Elongation at Break

The physical properties of the poly(trimethylene terephthalate) yarns reported in the following examples were measured using an Instron Corp. tensile tester, model no. 1122. More specifically, elongation to break, E_b , and tenacity were measured according to ASTM D- 2256.

Leesona Skein Shrinkage Test

The well-known Leesona Skein Shrinkage test was used to measure bulk of the textured yarns. First, the number of wraps needed was determined by using the following formula:

5 Number of wraps = $12,500 \text{ denier} / (\text{yarn denier} \times 2)$

Then a skein was wound on a reel using the number of wraps determined from the above equation, and the circumference of the reel was measured for use in the final calculations. Then, a 20-gram weight of the skein was hung and the skein was removed from the reel. (The skein was not allowed to relax.) While the skein
10 was still hung under the 20-gram tension, it was completely immersed in a container of water at 180°F for 10 minutes. The skein was removed from the container of water (without removing the weight), and after two minutes the length of the skein was measured with the 20-gram weight still on. The skein shrinkage was calculated using the formula:

15 Per cent Skein Shrinkage = $(LO - LF \times 100) / LO$,

where LO = Original Length of skein (one-half circumference of the reel), and LF = Final Length with weight attached after hot treatment.

Polymer Blends

Poly(trimethylene terephthalate) compositions were prepared from
20 Sorona® semi-dull poly(trimethylene terephthalate) (CP Polymer) pellets having an IV of 1.02 and containing 0.3 weight % TiO₂ (DuPont)) (poly(trimethylene terephthalate)) by itself (control) or with Surlyn® 8920 ionomer (DuPont), Sigma-Aldrich polystyrene 43,010-2 (having a Melt Index of 7.5 g/10 min (ASTM 1238, 200°C/5 kg), Softening Point of 107°C (ASTM-D1525), Mn of 83,000 (ASTM D
25 5296-97)), or Crastin® 6129 Poly(tetramethylene terephthalate) (DuPont).

The following procedures were used:

Procedure A.

Poly(trimethylene terephthalate) pellets were compounded with ionomer, 4GT, or polystyrene using a conventional screw remelting compounder with a
30 barrel diameter of 30 millimeters (mm) and a MJM-4 screw (Werner & Pfleiderer Corp., Ramsey, NJ). The extrusion die was 3/16 inches (4.76mm) in diameter with a screen filter at the die entrance.

The poly(trimethylene terephthalate) pellets were fed into the screw throat using a K-tron 5200 feeder (K-Tron International, Inc., Pitman, NJ) with a 15 mm
35 hollow auger and 25 mm tube. The nominal base polymer feed rate was dependent on the weight % used.

The ionomer, polystyrene (PS) or 4GT pellets (see Table 1) were also fed into the screw throat using a K-tron T-20 feeder with twin P1 screws. Only one spiral feeder screw was used. A vacuum was typically applied at the extruder throat.

5 The barrel sections of the compounder were held at the following temperatures. The first heated barrel section was turned off. The second and third sections were set at 170°C. The remaining eleven sections were set at 200°C. The screw was set at 225 revolutions per minute ("rpm") yielding a melt temperature of 250°C at the extrusion die.

10 The extrudant flowed into a water bath to solidify the compounded polymer into a monofilament. Then two sets of air knives dewatered the filament before entering a cutter that sliced the filament into 2 mm length pellets.

Procedure B.

15 The pellets from procedure A (or poly(trimethylene terephthalate) pellets in the control examples) were placed in a vacuum oven for drying for a minimum of 16 hours at 120°C. The dried pellets were removed from the oven and quickly dropped into a nitrogen blanketed supply hopper that was maintained at room temperature. The pellets were fed to a twin screw remelter at 100 grams per minute (gpm). The barrel heating sections were set to 240°C for zone 1, 265°C for zones 2 to 5, 268°C for zones 7-8. Pump block was 268°C, pack box heater was 268°C.

Example 1 – Partially Oriented Yarn Preparation

25 Partially oriented yarns were spun using conventional spinning techniques from poly(trimethylene terephthalate) blended according to Procedure A or by itself.

30 Poly(trimethylene terephthalate) or poly(trimethylene terephthalate) blend prepared using Procedures A and B was extruded through a sand filter spin pack and a 34 round hole spinneret (0.012 inch (0.3 mm) diameter and 0.022 inch (0.56 mm) capillary depth holes) maintained at 273°C. The filamentary streams leaving the spinneret were quenched with air at 21°C, converged to a bundle and spin finish applied. Forwarding rolls with a subsurface speed described in the table below delivered the yarn bundle to an interlace jet and then onto a windup running at the speed described in the table below.

35 The spinning conditions and properties of the resultant partially oriented yarns are described in Table 1.

Table 1. Spinning Conditions & Partially Oriented Yarn Properties

Sample No.	S ¹ wt%	PS ² wt%	4GT ³ wt%	Spinning Godet Speed, m/m	Winding Speed, m/m	Yarn Denier	DPF	Tenacity (g/d)	E _b , %
A (control)	-	-	-	2500	2535	211	6.2	2.11	97.8
B (control)	-	-	-	2500	2530	212	6.2	2.25	106.0
C (control)	-	-	-	2500	2550	211	6.2	2.35	109.2
D (control)	-	-	-	3500	3550	152	4.5	3.10	70.7
1	2	-	-	3000	3030	202	5.9	2.53	86.9
2	1	1	-	3000	3030	212	6.2	2.22	107.7
3	1	-	1	3000	3030	209	6.2	2.59	91.2
4	0.67	0.67	0.67	3000	3030	202	5.9	2.43	95.4
E (Comp)	-	2	-	3000	3030	204	6.0	2.19	106.1
F (Comp)	-	-	2	3000	3030	207	6.1	2.09	111.7

1. Surlyn® 8920 ionomer.
2. Polystyrene.
3. Poly(tetramethylene terephthalate).

5 Poly(trimethylene terephthalate) partially oriented yarns have to be spun at slow speeds (ca. 2,500 m/m) to be suitable for draw-texturing operations. The data in Table 2 shows that the partially oriented yarns of this invention are suitable for draw-texturing when prepared at significantly higher spinning speeds.

10 The control samples show that with increased spinning and windup speed elongation to break drops and tenacity increases. Products made at higher speeds were not sufficiently suitable for draw-texturing operations. With addition of ionomer, the partially oriented yarns spun at higher speeds had properties suitable for draw-texturing operations. Most notably, the ionomer containing yarns spun at 3000 m/m had properties similar to the control yarns that were spun
15 at 2500 m/m, so that they could be draw-textured under similar conditions. As a result, using the invention partially oriented yarns can be prepared at higher speeds and can be used for draw-texturing without significant modifications to the draw-texturing operation. In addition, the invention enables use of equipment designed for making poly(ethylene terephthalate) partially oriented yarns at the
20 higher speeds it was designed for.

Example 2 – Draw-texturing

This example shows that yarns produced according to the invention are useful in subsequent draw-texturing operations.

25 The draw-texturing conditions use a friction false-twist texturing process using an apparatus described in Figure 5 of U. S. Patent 6,287,688, which is incorporated herein by reference. Partially oriented yarns prepared as described in Example 1 were heated to a temperature of about 180°C as they passed through the heater and cooled to a temperature below the glass transition temperature of

poly(trimethylene terephthalate) as they passed over the cooling plate. Take-up speed was 500 m/m.

The remaining draw-texturing process conditions and the properties of the resulting draw-textured poly(trimethylene terephthalate) yarn are set forth in

- 5 Table 2 below. In this Table, the draw ratio is given as the ratio of the speed of the draw roll to the speed of the feed roll.

Table 2. Texturing

Sample No.	S wt%	PS wt%	4GT wt%	Draw Ratio	Yarn Denier	DPF	Tenacity g/d	E _b , %	Leesona Shrinkage
A (Control)		-		1.35	163	4.8	2.68	43.0	47.6
B (Control)		-		1.44	160	4.7	2.77	42.7	42.0
1	2	-	-	1.45	154	4.5	2.78	44.3	40.4
2	1	1	-	1.42	156	4.6	2.73	38.1	41.6
3	1	-	1	1.33	168	4.9	3.08	42.4	42.8
4	0.67	0.67	0.67	1.33	164	4.8	2.92	43.7	44.8
E (Comp)	-	2	-	1.42	157	4.6	2.83	46.1	43.6
F (Comp)	-	-	2	1.33	164	4.8	2.68	45.7	44.4

- 10 The data in Table 2 shows that textured yarns prepared from the partially oriented yarns prepared according to the invention have properties comparable to poly(trimethylene terephthalate) yarns prepared from the control samples. This data shows that it is possible to prepare textured yarns from the partially oriented yarns of this invention under similar conditions to those used with poly(trimethylene terephthalate) partially oriented yarns spun at lower speeds.

- 15 The foregoing disclosure of embodiments of the present invention has been presented for purposes of illustration and description. It is not intended to be exhaustive or to limit the invention to the precise forms disclosed. Many variations and modifications of the embodiments described herein will be obvious to one of ordinary skill in the art in light of the disclosure.

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